

Work Order ID 55155

January 7, 2010 1:31:36 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



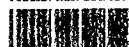
Item Name: High-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 1000



Cost Item ID:

Required Date: 10/02/2010 Req'd Qty: 1000



Customer:

Reference:

Run Start



Approvals:

Process Plan:

BS

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/10/02/08

MF 10/02/05

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig D78719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *1111311*
1111494

3-Grind End Plate flush

10.01.26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55155

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Page 2

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Stop, Long RM

Start Date: 07/01/2010 Start Qty: 1000



Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 1000



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.01.26 (10)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8.10.1.26

X/D
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



Hand Finish

Memo

0.00

Hand Finishing

10.01.28

10 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55155

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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Stop, Long RH

Start Date: 07/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAN

10-01-28

10

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

10

10

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod MI11311

6-Grind End Plate flush

7-Install last rivet as per Dwg

10-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.02.01

(10)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 10.02.01

X10
RH

210

Chemical Conversion Coater QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ M 10/02/07

X10AH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55155

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Item ID: D350-591-512

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 10.00

Cost Item ID:

Required Date: 10/02/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref 4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Powder Coating

M112588

Memo

START TIME: 1:15pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:45pm

0.00 => M 10/02/05

(X10) 0

230

Wing Walk as per dwg QS1005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

BR 10-02-4

(10) 0

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00 10/02/05

+10
RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55155

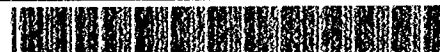


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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010 Start Qty: 10.00

Cost Item ID:

Required Date: 10/02/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

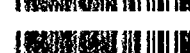
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
260	QC4- 100% Inspect kits for completeness	0.00							
	QC								
	Quality Control								
	Memo	0.00							
270	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per RPPD350-591-312								
	Location:								

10-2-5 10x

8/10/02/08

FORN

REUB

10-2-8 sl 10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55155

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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Stop, Long RH

Start Date: 07/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09

MF

10-2-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 09/02/2010

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev: A 04.03.22 New issue KIRF

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by EC

IPP Rev: D 08-04-08 ECN1164 DD verified by EC

D3063-041

Manufactured No

Each

60.0000

10.0000



Step Leg Assembly Hi

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

53523

14

Main Warehouse

WA

46

52104

62

53795

40

D3066-1

Manufactured No

Each

102.0000

20.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

102

51545

11

53783

91

D3219-1

Manufactured No

Each

122.0000

20.0000



Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

122

53789

122

10.02.01

8

2

10.02.01

20

10.01.26

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.02 New issue KJ/RF

Start Qty: 10.00

Required Qty: 10.00

IPP Rev: B 07-06-02 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN 1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN 1164 DD verified by: cC

D3067-1 Manufactured No 110 Each 113.0000 10.0000



End Plate

10-01-26

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

113

53784

113

D3272-1 Manufactured No 110 Each 0.0000 10.0000



Step

MS21042L5

Purchased No



Nut

110 Each 1,005.000 20.0000

10-01-19 855157

10-2-8 100 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1005

110382

10

111636

11

112314

484

113523

300

113537

200

20

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 08/02/2010

Comments: IPP Rev: A 04.03.22 New issue KJRF

Start Qty: 10.00

Required Qty: 10.00

IPP Rev: B 07-06-09 Added D3572-1 RM

IPP Rev: C 08-04-02 ECN1161 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: EC

MS20600-AD4W4

Purchased

No

130

Each

1,683.000 160.0000



Rivets

10.02.01

Warehouse

Loc Qty

Lot Code

Location

Main Warehouse

ST

1683

110731

215

111359

46

111477

74

112314

824

112385

24

113368

500

1160

AN3-35A

Purchased

No

260

Each

261.0000 20.0000



Bolt

10-2-5 sd

Warehouse

Loc Qty

Lot Code

Location

Main Warehouse

ST

261

106993

12

110467

1

112314

248

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order #: 55155



Parent Item: D350-501-342



Parent Item Name: Pick-Across-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: RPP Rev: A 04-03-22 New issue KJ/RF

Start Qty: 10.00

Required Qty: 10.00

RPP Rev: B 07-06-07 Added D3572-1 JLM

RPP Rev: C 06-04-07 BCN1163 DD verified by: EC

RPP Rev: D 08-04-07 BCN1164 DD verified by: EC

AN4-13A Purchased No 260 Each 549.0000 \$0.0000



5-10 Bolt



10-2-5

sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

569

113359

569

17406

0

51764

0

80

AN5-36A Purchased No 260 Each 175.0000 20.0000



5-10 Bolt



10-2-5

sl

100

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

175

109545

11

110467

7

110731

4

112243

20

112314

83

112385

50

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RM

Start Date: 07/01/2010

Required Date: 03/32/2010

Start Qty: 10:00

Required Qty: 10:00

Comments: IPP Rev: A ☐ 04.03.22 ☐ New issue ☐ K3/MF ☐
 IPP Rev: B 07-06-09 Added 125572-1 HAM
 IPP Rev: C 08-04-02 ECN 1163 DD verified by JEC
 IPP Rev: D 08-04-08 ECN 1164 DD verified by JEC

AN960JD10

Purchased

No

260

Each

998.0000

40.0000

(17x)

M113368

M113288

(23)

Washer

1149003631

QSI 617

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

998

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

78

112369

22

113149

608

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 7, 2010 1:31:42 PM

Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev: A 04-03-22 New issue ☐ KJ/RF ☐

IPP Rev: B 07-06-01 Added D3572-1 JLM

IPP Rev: C 08-04-01 BCN1163 DD verified by: EC

IPP Rev: D 08-04-01 ECN1164 DD verified by: cC

Start Date: 07/01/2010

Required Date: 10/02/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD416

Purchased

No

260

Each

1,439.000 160.0000



Washer

NAS1149004634

QSI 017

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1489

103691

20

104215

6

108161

529

110523

340

111279

101

111916

482

112314

211

16941

0

AN960JD516

Purchased

No

260

Each

589.0000 40.0000



Washer

NAS1149005634

QSI 017

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

589

110363

46

110523

57

111279

39

112082

64

112314

14

112828

18

113149

351

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long KH

Start Date: 07/01/2010

Register Date: 08/02/2010

Start Qty: 10.00

Supplied Qty: 10.00

Comments:

IPP Rev: A 04-03-22 New issue OKKRF

IPP Rev: B 07-06-09 Added D3572-1 ALM

IPP Rev: C 08-04-02 ECN1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: EC

D2230-3

Manufactured No

260

Each

177.0000 40.0000



Lug

10-2-5 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST136

100

53881

100

40

Main Warehouse

ST496

70

53781

70

D2618

Manufactured No

260

Each

121.0000 20.0000



Bushing

10-2-5 (10x) SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

121

50989

121

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

January 7, 2010 1:31:42 PM

Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments:

IPP Rev: A 04-03-20 New issue ☐ KJ/RF ☐
 IPP Rev: B 07-06-01 Added D3572-1 JLM
 IPP Rev: C 08-04-01 ECN1163 DD verified by: EC
 IPP Rev: D 08-04-01 ECN1164 DD verified by: EC

Start Qty: 10.00

Required Qty: 10.00

D2856-400 *x2 @ 7 20⁰¹* Manufactured No 260 f 290.3921 6.0000



Abraison Strip

10-2-5 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST403

290.3920842

50593

141.312884

52563

149.08

260

Each

115.0000

10.0000

sl 10-02-01

D3067-1



End Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

113

53784

113

260

Each

35.0000

20.0000

*10
B54759 (9) 10-2-5 sl (10x)*

D3235-1



Mounting Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

35

45398

4

53785

31

11

January 7, 2010 1:31:42 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 7, 2010 1:31:42 PM

Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New issue K/MRF

Start Qty: 10.00

Required Qty: 10.00

IPP Rev: B 07-06-09 Added D3572-1 JLM

IPP Rev: C 08-04-02 ECN1163 DD verified by: EC

IPP Rev: D 08-04-08 ECN1164 DD verified by: EC

D3278-041

Manufactured No

260

Each

53.0000

10.0000



Support Assembly

10-2-5 S

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

52075

13

53227

40

3
7

MS21042L3

Purchased

No

260

Each

2,916.000

20.0000



Net

10-2-5 S (10x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2916

110844

35

111274

27

111668

52

112314

1302

112385

500

113521

300

113537

700

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

January 7, 2010 1:31:42 PM

Work Order ID: 55155

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Stop, Long RH

Comments: IPP Rev: A 04-03-22 New iss: KJ/RF

IPP Rev: B 07-06-09 Addel: 2572-1 JLM

IPP Rev: C 08-04-02 ECN153 DD verified by: EC

IPP Rev: D 08-04-08 ECN154 DD verified by: cC

Start Date: 07/01/2010

Required Date: 10/22/2010

Start Qty: 10.00

Required Qty: 10.00

MS2104214

Purchased

No

260

Each

4,009.000 \$0.0000

6
40



Nut



10-2-5

100 of

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4009

102552

6

104248

6

110507

184

111827

2813

113422

1000

15924

6

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE N/A
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.18 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3066-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20800AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55155
BA 10-1-07

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

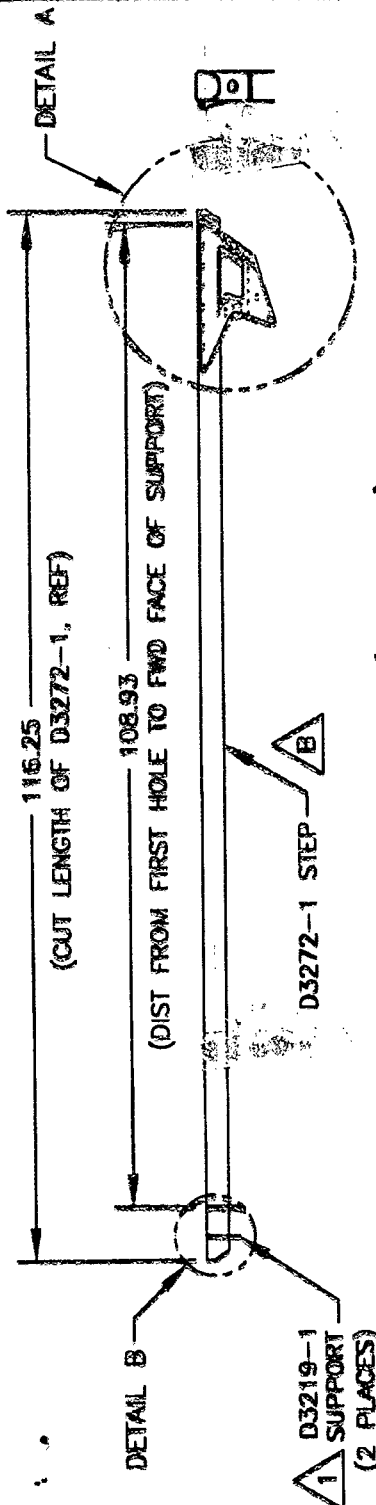
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

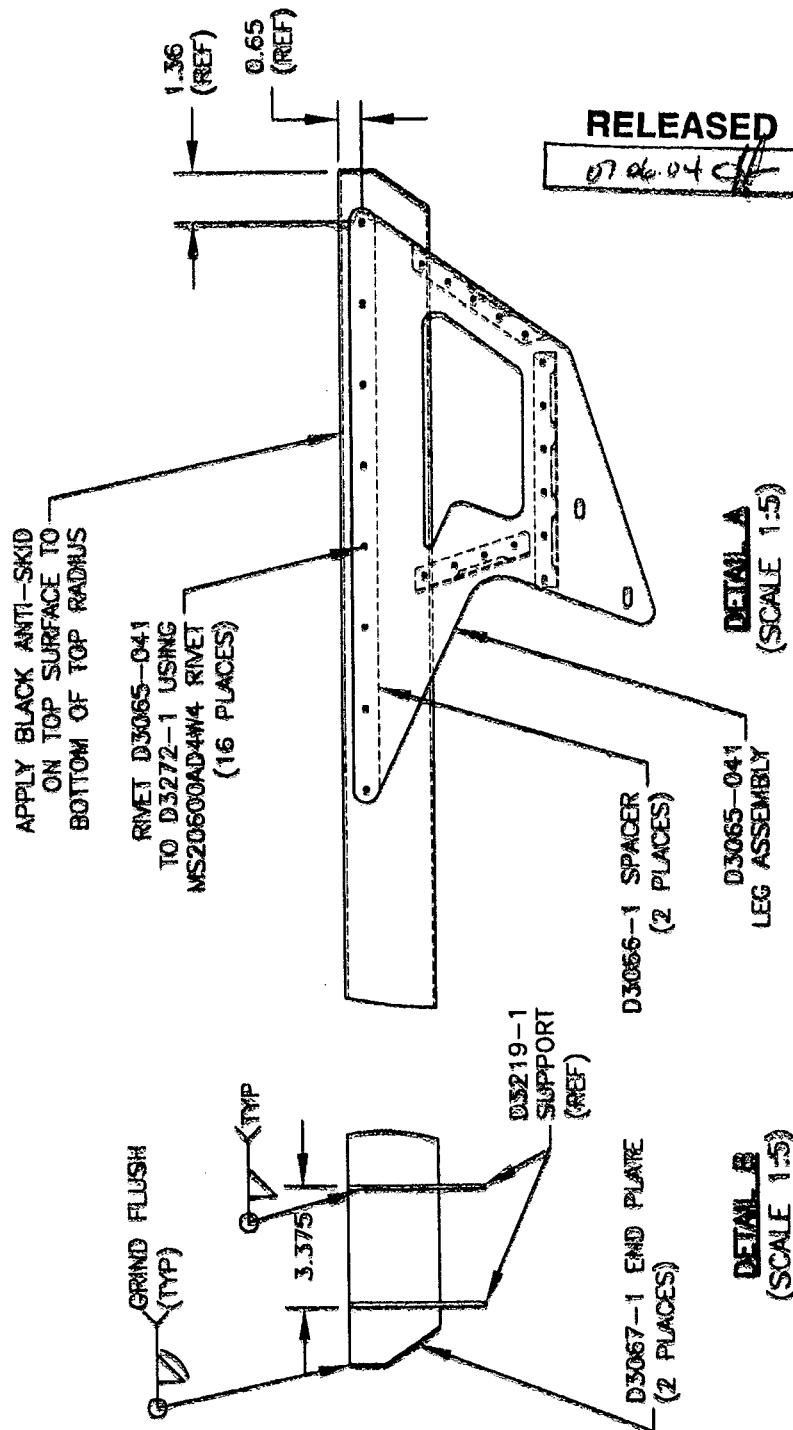
DART

DESIGN <i>97</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. 8 SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

W10 55155



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

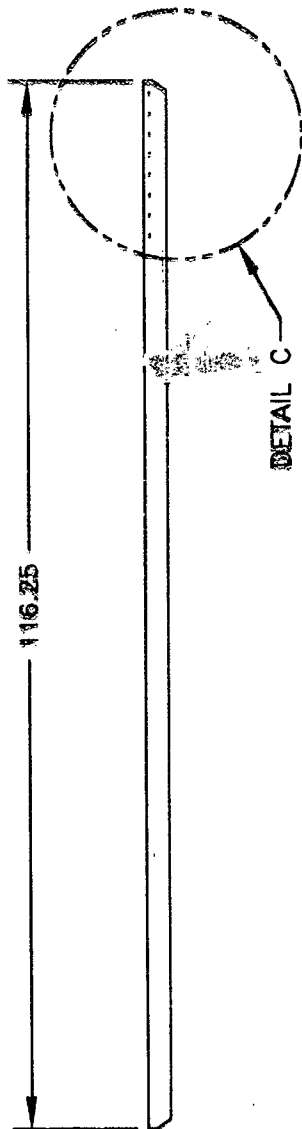


W/D 55155

DESIGN GP	DRAWN [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

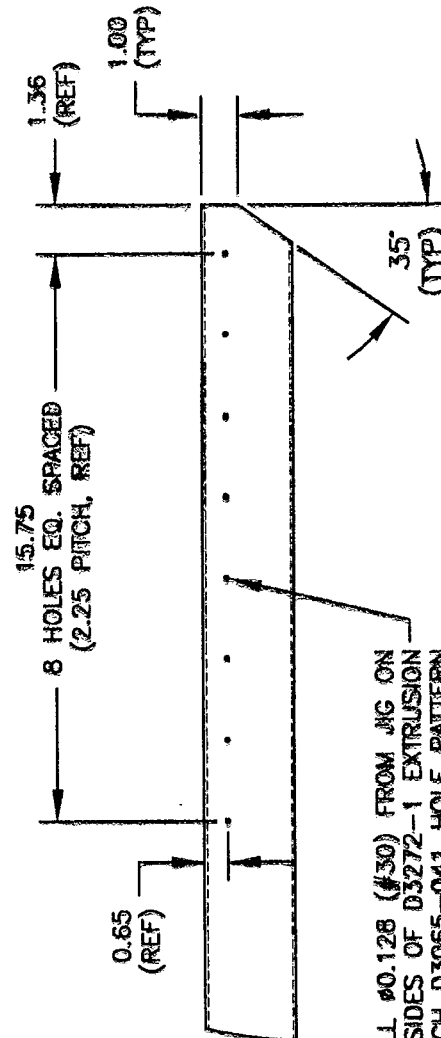
07.06.04 **[Signature]**



DETAIL C

△ D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL #0.128 (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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